

BLUE

Dart Aerospace Ltd.

Date: Wednesday, 12/11/2008 1:41:00 PM
User: Julie Dawson

Process Sheet

| | | | |
|-----------------------|--|------------------|------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : 02.250 SUPPORT |
| Job Number | : 43383 | | |
| Estimate Number | : 11057 | | |
| P.O. Number | : | Part Number | : D28911 |
| This Issue | : 12/11/2008 S.O. No. : | Drawing Number | : D2891 -BLUE |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : / / | Drawing Revision | : A1 |
| Previous Run | : 41198 | Material | : |
| Written By | : | Due Date | : 10/12/2008 |
| Checked & Approved By | : <u>2008.11.12</u> | Qty: | 12 Um: Each |
| Comment | : Est. C 02.11.26 Added P/O KJ Est D 08.03.19 Re-format EC verified: DD | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|--------|------------------------|
| 1.0 | DSK076 | D2891-1 TURNING DETAIL |
|-----|--------|------------------------|



Comment: Qty.: 0.5000 Each(s)/Unit Total: 6.0000 Each(s)

D2891-1 TURNING DETAIL

Batch: 842244

mmt 08/11/23

| | | |
|-----|-------|--------------------------------|
| 2.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS

Machine as per Folio FA046

Tumble & Deburr

mmt / J.L 08/11/25

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mmt / J.L 08/11/25

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

29 08/11/29 (P)

| | | |
|-----|----------------|----------------|
| 5.0 | SPRAY PAINTING | SPRAY PAINTING |
|-----|----------------|----------------|



Comment: -PRIME B 10992

-PAINT DELFLEET BLUE B 110077

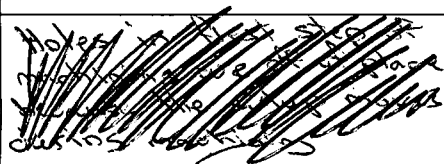
-CLEAR DELFLEET B 110161

CC 08-12-10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---------------------|---------------------|--|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 10/10/00 | 10/10/00 |  | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 12/11/2008 1:41:01 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 02.250 SUPPORT

Job Number: 43383

Part Number: D28911

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC14

INSPECT SPRAY PAINT



m 08 12 11

(12)



Comment: INSPECT SPRAY PAINT

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *x-tube* Ass

m 08 12 11

(12)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/11 *MF*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12/11

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|------------------------------------|----------------|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 43383 |
| Description: Ø2.250 Support | | Part Number: D2891-1 |
| Inspection Dwg: D2891 | Rev: A1 | Page 1 of 1 |

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

| | | | | Record Actual Dimensions | | | | |
|---------------|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | 5 |
| HAAS Section | | | | | | | | |
| AA | 0.188 | 0.193 | | .191 | .192 | .192 | .191 | .191 |
| AB | 0.240 | 0.260 | | .250 | .247 | .252 | .249 | .250 |
| AC | 0.115 | 0.150 | | .128 | .127 | .130 | .128 | .129 |
| AD | 0.040 | 0.060 | | .049 | .048 | .048 | .049 | .049 |
| AE | 0.010 | 0.020 | | .010 | .011 | .011 | .011 | .011 |
| AF | 0.240 | 0.260 | | .250 | .250 | .250 | .250 | .25 |
| AG | 0.290 | 0.310 | | .310 | .296 | .290 | .297 | .295 |
| AH | 0.115 | 0.150 | | .142 | .140 | .140 | .141 | .141 |
| AI | 0.454 | 0.474 | | .456 | .460 | .463 | .461 | .457 |
| AJ | 2.779 | 2.789 | | 2.783 | 2.782 | 2.782 | 2.781 | 2.782 |
| AK | 0.240 | 0.260 | | .250 | .250 | .250 | .250 | .250 |
| AL | 1.002 | 1.042 | | 1.036 | 1.042 | 1.041 | 1.041 | 1.042 |
| AM | 0.053 | 0.073 | | .063 | .063 | .063 | .063 | .063 |
| AN | 0.257 | 0.262 | | .260 | .261 | .261 | .261 | .261 |
| AO | 1.663 | 1.683 | | 1.671 | 1.671 | 1.671 | 1.667 | 1.669 |
| AP | 0.053 | 0.073 | | .063 | .063 | .063 | .063 | .063 |
| AQ | 0.022 | 0.042 | | .031 | .031 | .031 | .031 | .031 |
| AR | | | | | | | | |
| AS | | | | | | | | |
| AT | | | | | | | | |
| Accept/Reject | | | | | | | | |

| | |
|----------------------------|-----------------------|
| Measured by: mwe | Date: 08/11/24 |
| Audited by: mk | Date: 08/12/22 |
| Prototype Approval: | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 02.12.12 | New Issue | KJ/RF | |
| B | 08.04.21 | Reformat | KJ/JLM | |

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WORK ORDER
NO. _____

| | | |
|------------------------------------|----------------|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 43383 |
| Description: Ø2.250 Support | | Part Number: D2891-1 |
| Inspection Dwg: D2891 | Rev: A1 | Page 1 of 1 |

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

| | | | | Record Actual Dimensions | | | | |
|---------------|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| Dim | Min | Max | Go/No Go Gauge | 16 | 17 | 18 | 19 | 20 |
| HAAS Section | | | | | | | | |
| AA | 0.188 | 0.193 | | .191 | .191 | .191 | .191 | .191 |
| AB | 0.240 | 0.260 | | .255 | .255 | .250 | .245 | .245 |
| AC | 0.115 | 0.150 | | .129 | .129 | .127 | .130 | .127 |
| AD | 0.040 | 0.060 | .049 | .049 | .049 | .049 | .051 | .050 |
| AE | 0.010 | 0.020 | .011 | .015 | .015 | .015 | .015 | .015 |
| AF | 0.240 | 0.260 | | .250 | .250 | .250 | .250 | .250 |
| AG | 0.290 | 0.310 | | .300 | .300 | .300 | .300 | .300 |
| AH | 0.115 | 0.150 | | .141 | .140 | .140 | .140 | .140 |
| AI | 0.454 | 0.474 | | .459 | .461 | .461 | .462 | .462 |
| AJ | 2.779 | 2.789 | | 2.781 | 2.784 | 2.784 | 2.784 | 2.784 |
| AK | 0.240 | 0.260 | | .250 | .250 | .250 | .250 | .250 |
| AL | 1.002 | 1.042 | | 1.042 | 1.034 | 1.034 | 1.032 | 1.037 |
| AM | 0.053 | 0.073 | | .063 | .063 | .063 | .063 | .063 |
| AN | 0.257 | 0.262 | | .261 | .261 | .261 | .261 | .261 |
| AO | 1.663 | 1.683 | | 1.669 | 1.673 | 1.673 | 1.673 | 1.672 |
| AP | 0.053 | 0.073 | | .063 | .063 | .063 | .063 | .063 |
| AQ | 0.022 | 0.042 | | .031 | .032 | .032 | .032 | .032 |
| AR | | | | | | | | |
| AS | | | | | | | | |
| AT | | | | | | | | |
| Accept/Reject | | | | | | | | |

| | |
|--------------------------------|-----------------------|
| Measured by: mtc / J.L. | Date: 08/11/25 |
| Audited by: [Signature] | Date: 08/12/02 |
| Prototype Approval: | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|-------------|
| A | 02.12.12 | New Issue | KJ/RF | |
| B | 08.04.21 | Reformat | KJ/JLM | [Signature] |

| | | |
|------------------------------------|----------------|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 43383 |
| Description: Ø2.250 Support | | Part Number: D2891-1 |
| Inspection Dwg: D2891 | Rev: A1 | Page 1 of 1 |

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

| | | | | Record Actual Dimensions | | | | |
|---------------|-------|-------|----------------|--------------------------|-------|---|---|---|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | 5 |
| HAAS Section | | | | | | | | |
| AA | 0.188 | 0.193 | | .191 | .191 | | | |
| AB | 0.240 | 0.260 | | .249 | .250 | | | |
| AC | 0.115 | 0.150 | | .127 | .127 | | | |
| AD | 0.040 | 0.060 | | .048 | .049 | | | |
| AE | 0.010 | 0.020 | | .015 | .015 | | | |
| AF | 0.240 | 0.260 | | .250 | .250 | | | |
| AG | 0.290 | 0.310 | | .300 | .300 | | | |
| AH | 0.115 | 0.150 | | .140 | .140 | | | |
| AI | 0.454 | 0.474 | | .460 | .460 | | | |
| AJ | 2.779 | 2.789 | | 2.784 | 2.784 | | | |
| AK | 0.240 | 0.260 | | .250 | .250 | | | |
| AL | 1.002 | 1.042 | | 1.035 | 1.031 | | | |
| AM | 0.053 | 0.073 | | .063 | .063 | | | |
| AN | 0.257 | 0.262 | | .261 | .261 | | | |
| AO | 1.663 | 1.683 | | 1.671 | 1.672 | | | |
| AP | 0.053 | 0.073 | | .063 | .063 | | | |
| AQ | 0.022 | 0.042 | | .032 | .032 | | | |
| AR | | | | | | | | |
| AS | | | | | | | | |
| AT | | | | | | | | |
| Accept/Reject | | | | | | | | |

| | |
|----------------------------|-----------------------|
| Measured by: J.L | Date: 08/11/25 |
| Audited by: JML | Date: 08/12/02 |
| Prototype Approval: | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 02.12.12 | New Issue | KJ/RF | |
| B | 08.04.21 | Reformat | KJ/JLM | |

D2891-1

- 1) MATERIAL: 17-4 PH STAINLESS
HEAT TREAT TO H900
(900°F FOR 1 HR, AIR
MIN UTS = 170 KSI
- 2) IDENTIFY WITH DART LOGO (PER
GRAPHIC) AND PART NUMBER
0.125 HIGH LETTERING 0.010
- 3) BREAK ALL UNMARKED SHARP
- 4) PART IS SYMMETRIC ABOUT CEN
- 5) TOLERANCES ARE PER DART QS
X.XXX = ± 0.010 UNLESS OTH
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (F
QSI 005 4.3

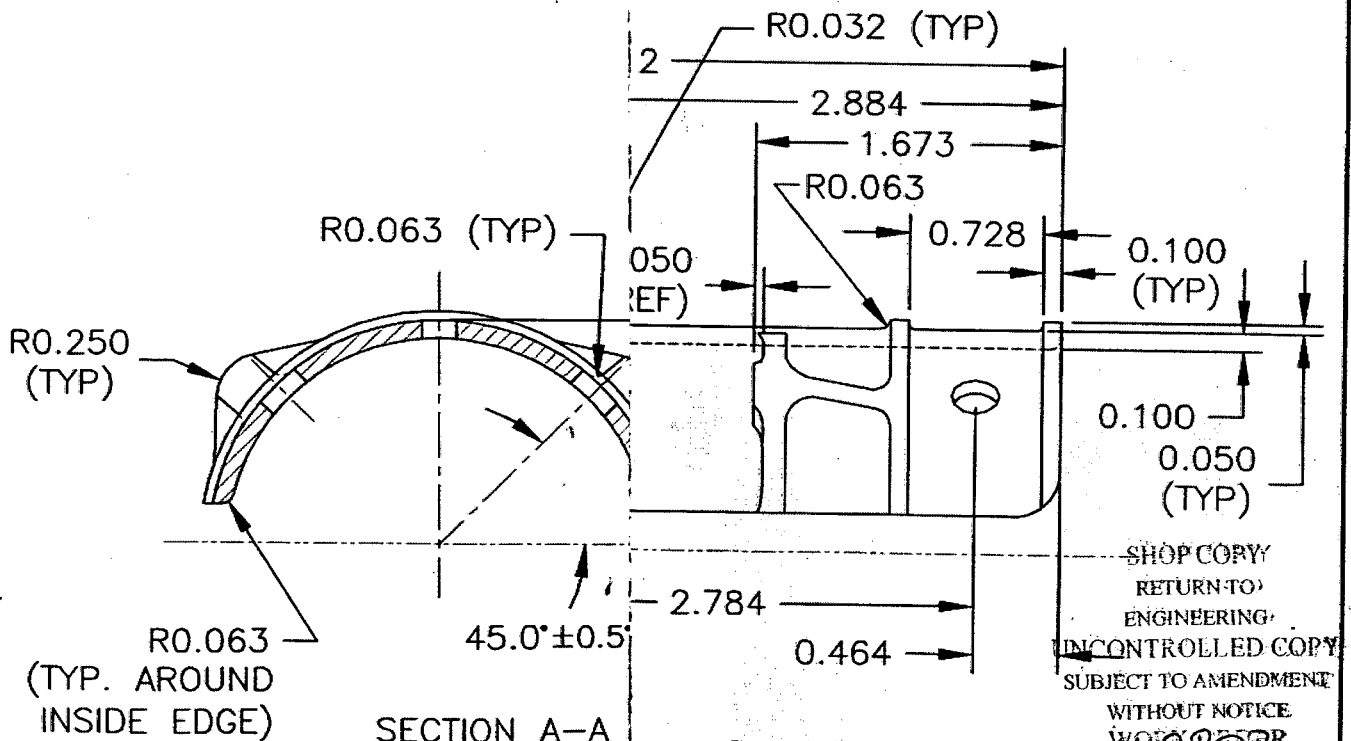
$\phi 0.188$
(TYP 2 PLACES)



$\phi 0.257$ (TYP 4 PLACES)

0.250 SPHERICAL RADIUS
FAIRING FLANGES TO
MAIN BODY (TYP)

R0.250 (TYP)



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WITHOUT NOTICE
NO. 43383



| | |
|-------------------------|--|
| 02-01-23 | UPDATE DIMS AS MANUFACTURED |
| 00-11-17 | NEW ISSUE |
| DRAWN BY CP | DART DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA |
| APPROVED [Signature] | DRAWING NO. D2891 |
| | TITLE Ø2.250 SUPPORT |
| | REV. A SHEET 1 OF 1 SCALE 1:1 |